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D2648-3**Job Sheet 209228****Part No:** D2648-3**Job Qty:** 10 pcs**Part Name:** Wearpad**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 4/16/20**Job Tracking No:****Due Date:** 4/27/20**Created By:** Marie Lajeunesse**Type:** SOLD**Description:**

Note: DWG REV D IPP: E 02.09.18 Re-format; Incorporated D2648-1 KJ/RF IPP Rev:F Now on Waterjet 06-08-14 JLM

Ship Via:**Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	10 pcs		4/25/20	0.17	1.00	Waterjet - Flow		<i>Dr 20/04/17</i>
120	QC 8	10 pcs		4/25/20	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
							QC 8 - 76		
							QC 8 - 61		
							QC 8 - 66		
							QC 8 - 73		

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4/16/2020

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

140	Small Fab - Brake NC - B4B	10 pcs	4/25/20	0.25 0.25	Small Fab - Brake - 1 - B4B	
					Small Fab - Brake - 2 - B4B	
					Small Fab - Brake - 3 - B4B	APR 21 2020
150	Large Fab - Welded Assy-2-B4B	10 pcs	4/25/20	0.00 1.67	Large Fab - 1 - B4B	<i>a</i>
					Large Fab - 10 - B4B	
					Large Fab - 2 - B4B	
					Large Fab - 3 - B4B	
					Large Fab - 4 - B4B	
					Large Fab - 5 - B4B	
					Large Fab - 6 - B4B	
					Large Fab - 7 - B4B	
					Large Fab - 8 - B4B	
					Large Fab - 9 - B4B	
					Large Fab - 11 - B4B (Various)	
					Large Fab - 12 - B4B	
160	QC 10	10 pcs	4/25/20	0.00 0.00	QC 10 - 10	
					QC 10 - 18	
					QC 10 - 24	DAS 24
					QC 10 - 43	9-89
					QC 10 - 50	
					QC 10 - 58	
					QC 10 - 9	
					QC 10 - 68	
					QC 10 - 81	
170	QC 5	10 pcs	4/25/20	0.00 0.00	QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	DAS
					QC 5 - 24	24
					QC 5 - 3	9-89
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
180	Powdercoat - 3 Grey Sand - B4B	10 pcs	4/27/20	0.00 0.33	Powdercoat - 1 - B4B	
					Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	
					Powdercoat - 4 - B4B	20-04-28
190	QC 3	10 pcs	4/27/20	0.00 0.00	QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	

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				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	BER 20-04-28
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
				QC 3 - 82	
				QC 3 - 87	
200	Packaging 3-1 - Stock - B4B	10 pcs	4/27/20	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
					Packaging 3 - 36 - B4B
					Packaging 3 - 37 - B4B
210	QC 21 - SA	10 pcs	4/27/20	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53

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DAS
70
9-89

Part Op 100 - 1-Cut as per Dwg D2648
 Descriptions: 120 - QC8- Inspect parts - second check
 140 - 1-Form as per Dwg D2648 on CNC brake using Jigs DT 8261 and DT 8326.

- 150 - Weld per dwg A/R Hardcoat steel Batch: M151068 1-Weld as per Dwg D2648 using Jig DT 8210
 160 - QC10- Inspect visual per QSI004- ground welds
 170 - QC5- Inspect part completeness to step on W/O
 180 - Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 - START TIME: _____
 190 - QC3- Inspect Part Finish
 200 - Identify as per dwg & Stock Location: _____
 210 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M1010S16GA	1010/1025 sheet 16GA	.7500 sf (.075 ea)	100-Waterjet - Flow - 1	<u>F124428</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M1010S16GA	1	70	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Wearpad	1.965Inches ± 0.010	1.975 1.955		
2	Wearpad	2.715Inches ± 0.010	2.725 2.705		
3	Wearpad	3.500Inches ± 0.010	3.510 3.490		
4	Wearpad	0.220Inches ± 0.010	0.230 0.210		
5	Wearpad	0.300Inches ± 0.010	0.310 0.290		
6	Wearpad	0.375Inches ± 0.010	0.385 0.365	Radius	
7	Wearpad	0.128Inches ± 0.010	0.138 0.118	Radius	

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